

Work Order ID 99542

April-11-13 11:05:57 AM

99542

Page 1

Item ID: D2221

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 350 Basket Base

Start Date: 4/11/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: ML5

Date: 13-04-11

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 124816

PLEASE NOTE SEE DWG

IF MAKING -141/-041A CUT BUSHING ON BASE BOTH ENDS, OR -143/-043A CUT BUSHING ON ONE SIDE ONLY OF BASKET BASE AS PER DWG

Pl 13.4.18

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

13-04-13 09

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Item ID: D2221

Accept

N900040100

Setup Start ***NS1***

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Item Name: 350 Basket Base

Start Date: 4/11/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

13-04-18

(DAS)
09

1 1613-4-18

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Item ID: D2221

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 Basket Base

Start Date: 4/11/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00

130

Powdercoat

Powder Coating

Memo

1- Plug holes prior to

1ST COAT:

START TIME: 8:40

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:40

***** 2nd coat if necessary *****

2ND COAT:

START TIME: 9:13

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:45

1X M / 13/04/19

M125069

140 QC3- Inspect Part Finish 0.00

140

QC

Quality Control

Memo

1 φ 134-22



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Item ID: D2221

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 Basket Base

Start Date: 4/11/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/25/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location	0.00	99541						
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

1 ϕ BL 13-4-22

13/4/23

13-04-23

Picklist Print

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Page 1

Work Order ID: 99542

99542

Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/11/13

Required Date: 4/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1		Manufactured	No			100	Each	11.0000	1	1			
D2221-1									**			Pl 13.4.18	
Rib													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA005			5						
				86847			1						
				90856			3			1			
				98418			1						
				WA006			6						
				90106			6						
D2221-5		Manufactured	No			100	Each	12.0000	2	2			
D2221-5									**			Pl 13.4.18	
Rib													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA004			12						
				89193			10			2			
				94273			2						
D2221-7		Manufactured	No			100	Each	5.0000	1	1			
D2221-7									**			Pl 13.4.18	
Rib													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA004			5						
				98506			5			1			

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Work Order ID: 99542

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/11/13

Required Date: 4/25/13

Start Qty: 1.00

Required Qty: 1.00

✓

D2232-3

Manufactured No

100 Each 49.0000 2 2

D2232-3

Basket Hinge

**

PL 13.4.18

Location

Loc Qty

Loc Code

WA

5

97261

5

WA004

44

75581

2

98040

22

98473

20

②

✓

D2235-1

Manufactured No

100 Each 13.0000 2 2

D2235-1

Basket Rib

**

PL 13.4.18

Location

Loc Qty

Loc Code

WA004

9

66895

4

85602

4

86051

1

WA005

4

96126

4

397035 → ②

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Work Order ID: 99542

Parent Item: D2221

Parent Item Name: 350 Basket Base

99542

D2221

Start Date: 4/11/13

Required Date: 4/25/13

Start Qty: 1.00

Required Qty: 1.00

✓ D2581
D2581
Mounting Bracket

Manufactured No

100 Each 90.0000 2 2

**

Pl 13.4.18

Location	Loc Qty	Loc Code
WA	58	
96599	14	
98503	44	
WA004	32	
70766	2	
81253	1	
82506	2	
83230	3	
85452	2	
87706	2	
98108	20	

Manufactured No

100 Each 13.0000 2 2

**

Pl 13.4.18

✓ D3442-1
D3442-1
Shim

Location	Loc Qty	Loc Code
WA	13	
98076	13	

Manufactured No

100 Each 2.0000 2 2

**

Pl 13.4.18

✓ D3825-041
D3825-041
Rib Assembly (Basket End)

Location	Loc Qty	Loc Code
WA004	2	
97285	2	

398491 → ②

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/11/13

Required Date: 4/25/13

Start Qty: 1.00

Required Qty: 1.00

D3826-041

Manufactured No

100

Each

6.0000

2

2

**

PL 13.4.18

✓ *D3826-041*

Rib / Gusset Assembly

Location

Loc Qty

Loc Code

WA004

4

98092

4

WA006

2

98344

2

2

D3827-041

Manufactured No

100

Each

2.0000

1

1

**

PL 13.4.18
398452 → 1

D3827-041

Rib Assembly (Inboard)



Location

Loc Qty

Loc Code

WA005

2

89334

2

100

Each

9.0000

1

1

**

PL 13.4.18

D3832-1

Manufactured No

100

Each

9.0000

1

1

**

✓ *D3832-1*

Mesh (Base)

Location

Loc Qty

Loc Code

WA

9

87142

6

96614

2

98291

1

1

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Work Order ID: 99542

Parent Item: D2221

Parent Item Name: 350 Basket Base

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D2221

Start Date: 4/11/13

Required Date: 4/25/13

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

32.0000

2

2

D3833-1

Mesh (Base End Face)

**

Cpl 13.4.18

Location

Loc Qty

Loc Code

WA

18

98359

6

99268

12

WA007

14

77521

4

81259

1

89208

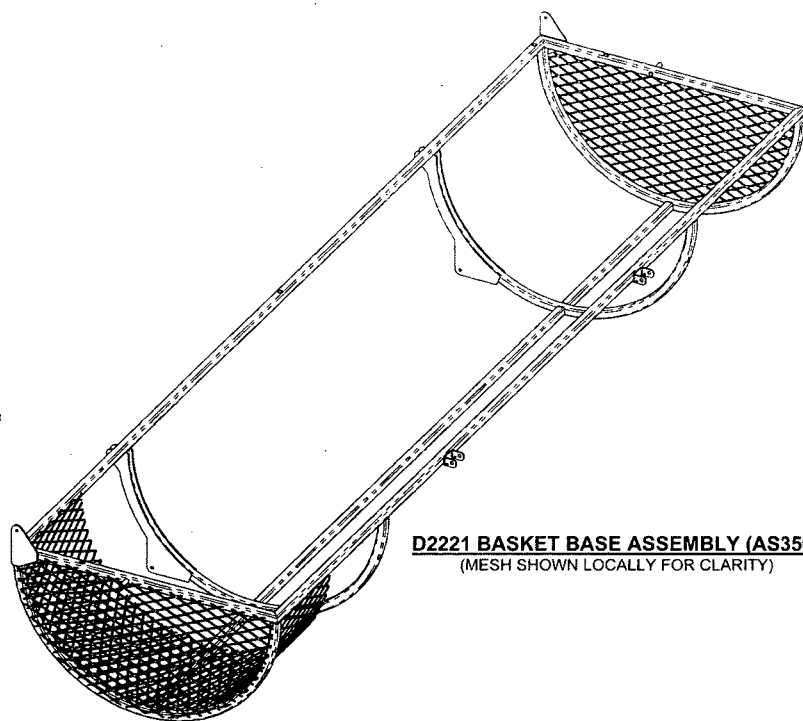
1

98538

8

①

①



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

UNCONTROLLED COPY
SUBMIT TO THE ELEMENT

WITNESS
VENDOR

NO 99542 MJS

13-04-11

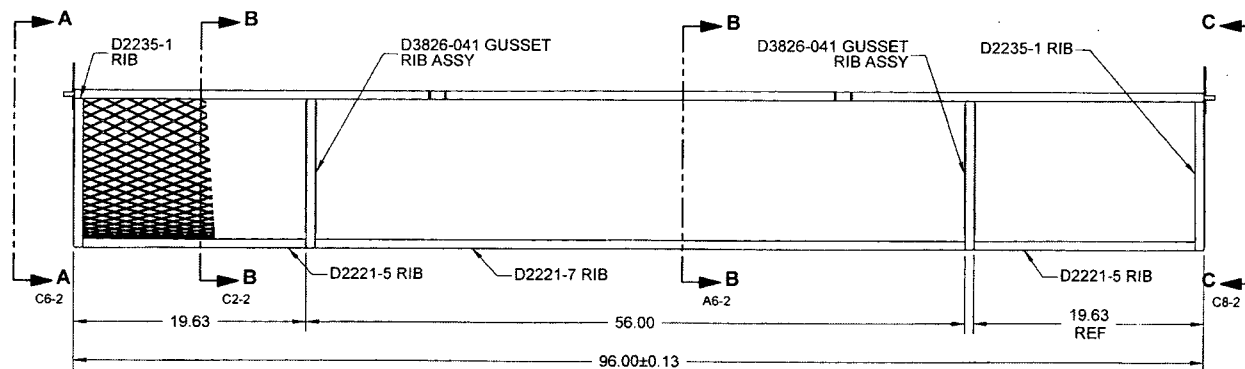
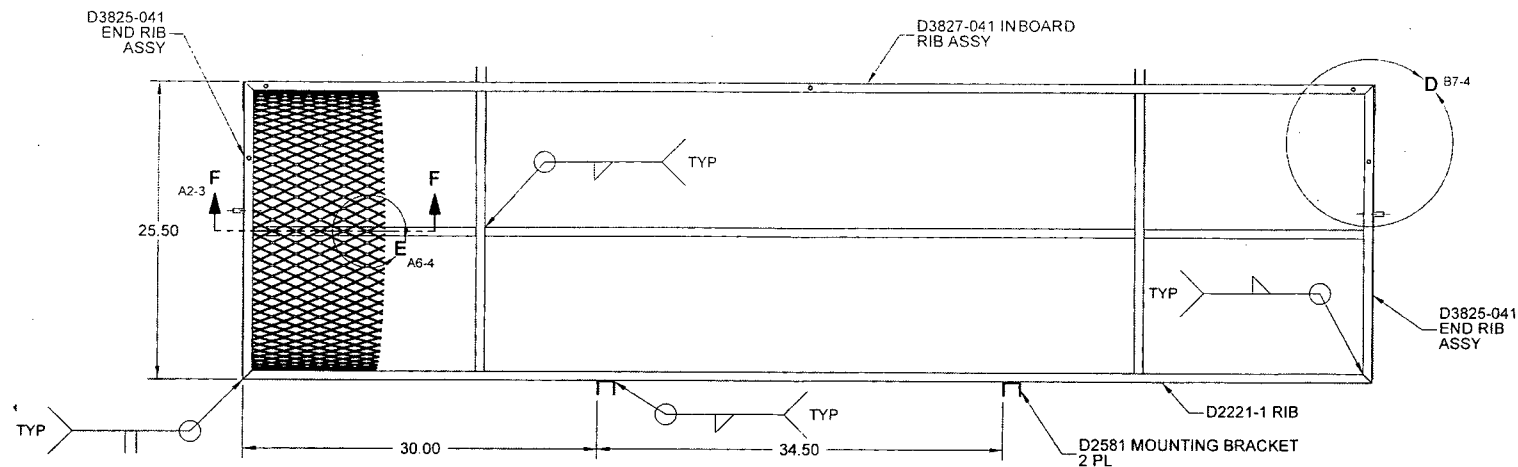
RELEASED

H	REVISED PARTS LIST AND ADDED 'ITEM' COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3625-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY 'LEAN MANUFACTURING' PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS 'HARD' DIMENSION IS NOW 'REF' (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO 'B' FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	MJS	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON, WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 42.00 lbs APPROX
- 8) MASK ALL HOLES PRIOR TO POWDER COATING

99542

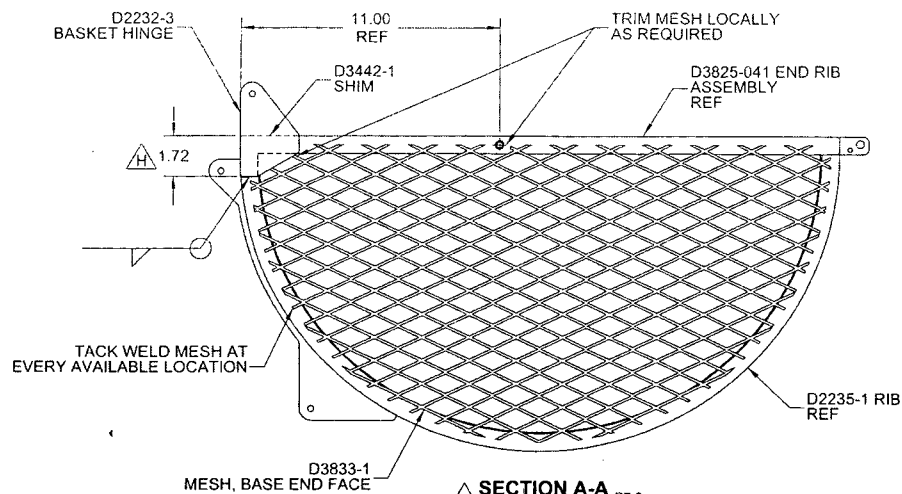


D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

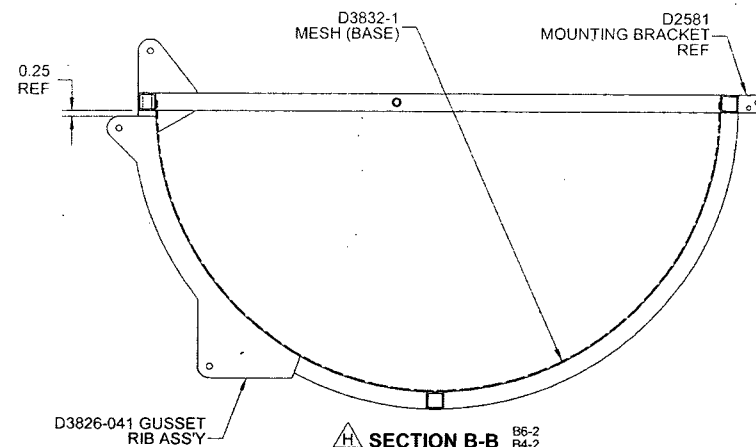
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06/11/18

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.		TITLE	SHEET 2 OF 5
APPROVED		BASKET BASE ASSEMBLY (350) NTS	
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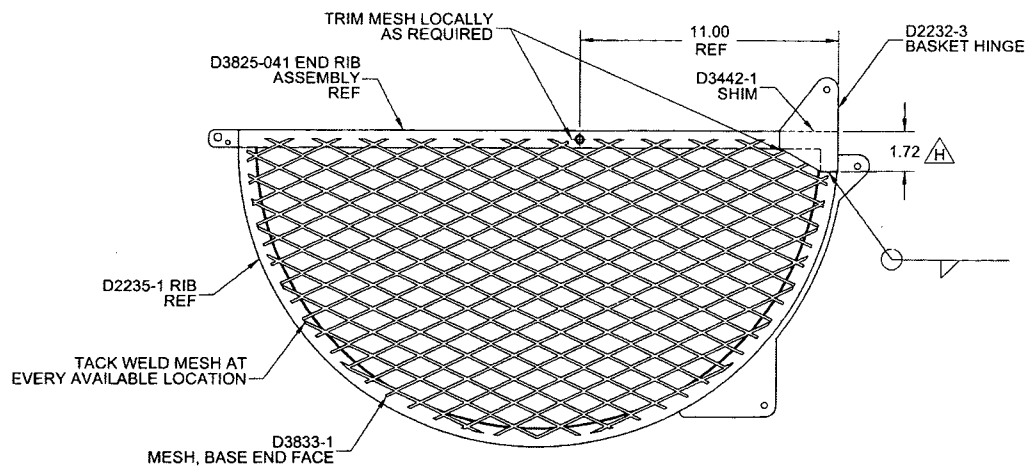
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SECTION A-A
SCALE 2X B7-2



SECTION B-B
SCALE 2X B6-2 B4-2
(D3833-1 MESH NOT SHOWN FOR CLARITY)

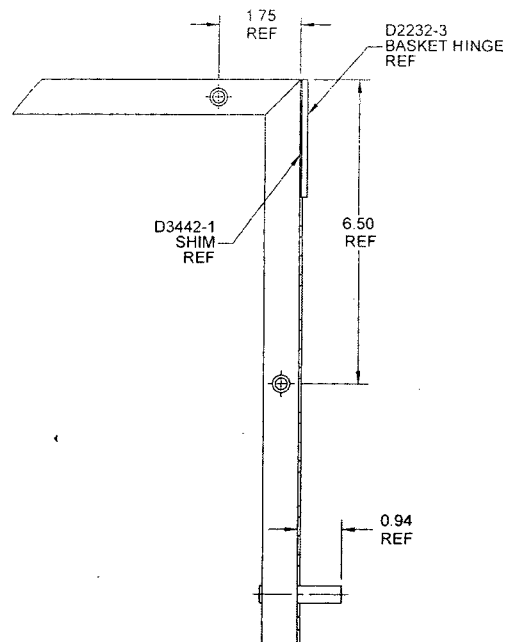


SECTION C-C
SCALE 2X B2-2

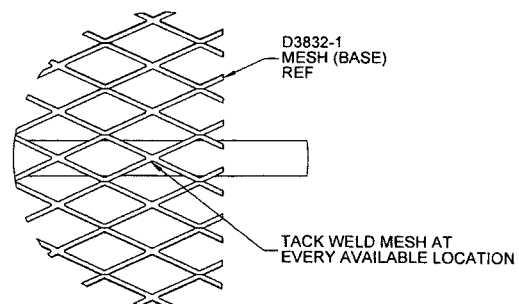
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02/11/18

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DRAWN	LS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MA	DRAWING NO. D2221	REV. H
MFG. APPR.	MA	SHEET 3 OF 5	
APPROVED	MA	SCALE	
DE APPR.	MA	BASKET BASE ASSEMBLY (350) INTS	
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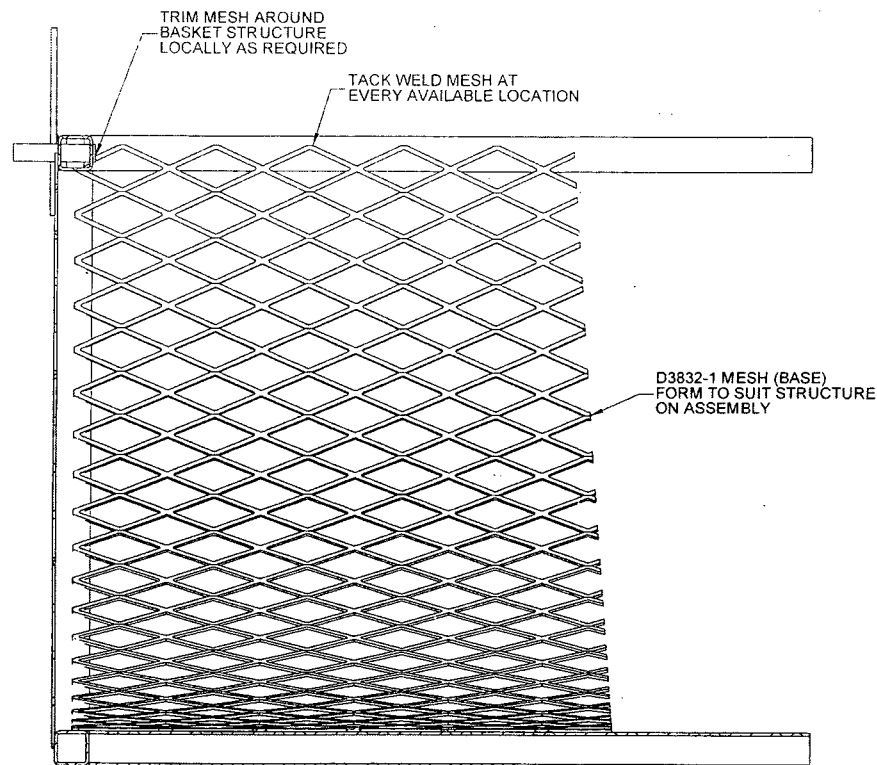
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DETAIL D
SCALE 4X D2-2



DETAIL E
SCALE 4X C6-2

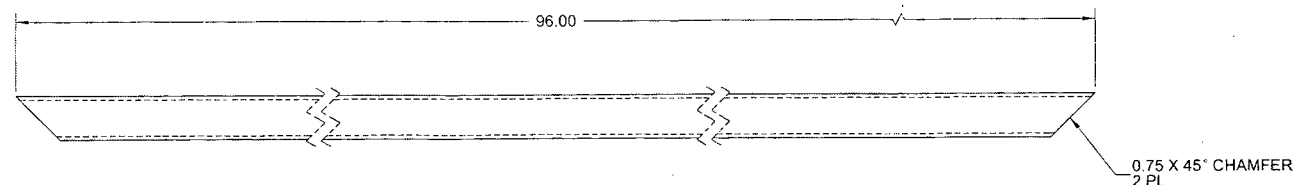
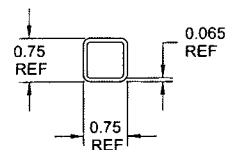
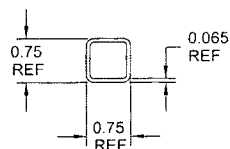


SECTION F-F
SCALE 4X D7-2

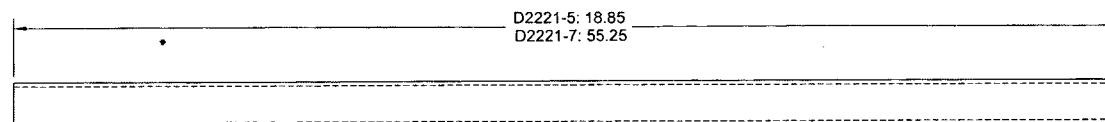
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08/11/18

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D2221	REV. H
MFG. APPR.		SHEET 4 OF 5	
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DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
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D2221-1 RIB



D2221-5/-7 RIB

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MS	D2221	SHEET 5 OF 5
APPROVED	MT	TITLE	SCALE
DE APPR.	SH	BASKET BASE ASSEMBLY (350)	NTS
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